

Work Order ID 50871

July 23, 2009 9:46:09 AM



Page 1

Item ID: D2873-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate Assembly

Start Date: 7/24/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 7/27/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2873	Rev A

100

0.00



BAND SAW

Bandsaw

0.00

Jeaspa Bandsaw

Memo

Cut blanks: 1.000" x 0.375" x 3.700" long

ML 09/07/24

20 6

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA and Dwg D2873. Identify as D2873-3
Dwg Rev A Folio Rev AA

/ S.L 09/07/25

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

Quality Control

/ S.L 09/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC8- Inspect parts - second check

0.00

88 09/07/27

QC

Quality Control

Memo

0.00

140



Small Fab

0.00

88 09/07/28



Small Fab

Small Fab

Memo

0.00

1-Deburr 112- C'sink as per Dwg D2873

150



QC5- Inspect part completeness to step on W/O

0.00

→ 88 09/07/28

QC

Quality Control

Memo

0.00

(cont)
88 09/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



Required Date: 7/27/2009 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BK 09-07-28 (20)

170



QC

QC3- Inspect Part Finish

0.00

0.00

M 09-07-28 (20)

Quality Control

180



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

I-Assemble as per Dwg D2873 2-Identify as D2873-043*EP 09/07/28 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

*coats
€20*

2) 8 or 28

200



Packaging

Packaging

Identify as per dwg & Stock Location: *X-tubos*

0.00

Memo

0.00

m 09 11 10 20

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/10 HJ

WDA MR 09-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

July 23, 2009 9:46:08 AM

Page 1
12

Work Order ID: 50871



Parent Item: D2873-043RevA



Parent Item Name: Nut Plate Assembly

Start Date: 7/24/2009

Required Date: 7/27/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	24.1095	6.4905			

6061T6 BAR .375 x 1.00



MS20426AD4-6

Purchased

No



Rivet

Warehouse

Location

Main Warehouse

MAT 24.10947368

105225 5.3

110829 18.8094737

10829

16.4905 7/24/09/07/24

MS20426AD4-6

Purchased

No



Rivet

Warehouse

Location

Main Warehouse

MAT -120

Main Warehouse

ST 4212

100151 27

103395 14

105144 370

110139 3774

2525 27

120

Warehouse

Location

Main Warehouse

MAT 24.10947368

105225 5.3

110829 18.8094737

10829

16.4905 7/24/09/07/24

EF 09/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

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Parent Item: D2873-043RevA



Parent Item Name: Nut Plate Assembly

Start Date: 7/24/2009

Required Date: 7/27/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5 		Purchased		No		100	Each	470.0000	60.0000		EPP09/07/28	

Nut Plate

Warehouse

Location

Main Warehouse

MAT -60

111127 -31

112243 -29

Main Warehouse

ST 530

110916 79

111127 31

112243 420

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	SO871
Description: RADIUS BLOCK	Part Number:	D2873-3
Inspection Dwg: 2873 Rev: A		Page 1 of 1

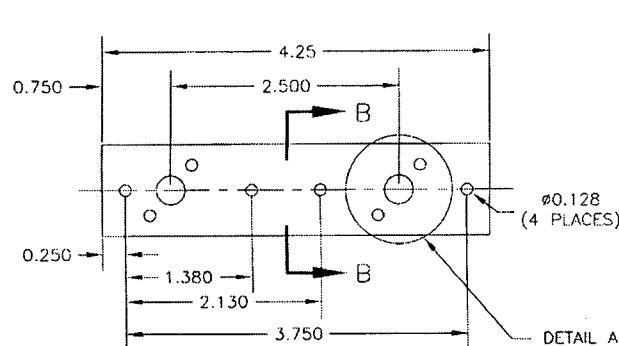
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>mt</u>	Audited by: <u>SP</u>	Prototype Approval:	N/A
Date: <u>09/07/24</u>	Date: <u>09/07/27</u>	Date:	N/A

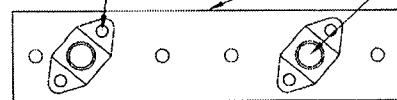
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

w/o 50871



D2873-1

MS20426AD4-6
RIVET
(TYP 4 PLACES)



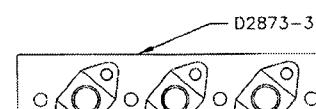
D2873-041

MS21075L5 NUT PLATE
(TYP 2 PLACES)



D2873-043

MS20426AD4-6
RIVET
(TYP 6 PLACES)

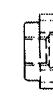


D2873-043

DETAIL A (TYP)

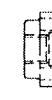
D2873-045

MS20426AD4-6
RIVET
(TYP 4 PLACES)



D2873-5

MS21075L5 NUT PLATE
(TYP 2 PLACES)



MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

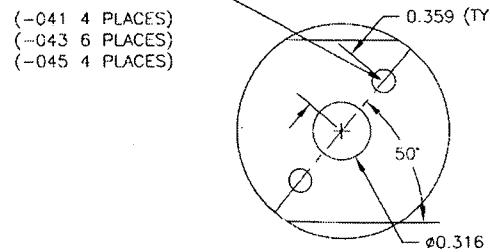
- 1) MATERIAL: 5052-H32/H34 BAR (QO-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QO-A-225/8 OR QO-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI D18 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

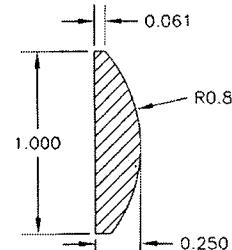
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

			PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
X			D2873-043	NUT PLATE ASSEMBLY
	X		D2873-045	NUT PLATE ASSEMBLY
1		D2873-1		RADIUS BLOCK
	1	D2873-3		RADIUS BLOCK
	1	D2873-5		RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED <i>ADS</i>	APPROVED <i>ADS</i>	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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